

Date: Tuesday, 10/3/2006 3:48:02 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 28863
Estimate Number : 10939
P.O. Number : N/A Part Number : D29382
This Issue : 10/3/2006 S.O. No. : N/A Drawing Number : D2938 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 27118 Material : N/A
Due Date : 10/30/2006 Qty: 8 Um: Each
Written By : SA 06/10/03
Checked & Approved By : SA 06/10/03
Comment : Est: B 00:06:26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length
(D6101-003) Batch No: B 25348 SA

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number. ✓
1-Inspect part number and batch number are programmed correctly. ✓
2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ✓
3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ✓
4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ✓
5-Deburr SA / J.L. 06/10/11

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet J.L. 06/10/11

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET SA / J.L. 06/10/11

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK SA 06/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:48:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28863

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y

06/10/11 X 8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

Y 06/10/12 X 8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m 06/10/13

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SI 347*

m 06/10/13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06.10.13

Job Completion



W 06.10.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28863
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.128	.122	.121	.121		
B	0.100	0.140		.128	.121	.121	.121		
C	0.100	0.140		.125	.119	.119	.118		
D	0.210	0.230		.220	.221	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.251		
F	1.245	1.255		1.250	1.251	1.250	1.250		
G	2.495	2.505		2.501	2.500	2.500	2.501		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.578	1.577	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.120	.120	.118		
O	0.540	0.560		.552	.552	.552	.551		
P	0.490	0.510		.501	.500	.501	.500		
Q	3.715	3.725		3.720	3.721	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.253	.252	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.631		
V	1.362	1.372		1.368	1.367	1.367	1.368		
W	0.316	0.321	DT8690	.318	.318	.318	.318		
X	1.250	1.270		1.260	1.259	1.259	1.258		
Y	1.565	1.585		1.574	1.573	1.572	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/10/10

Audited by:	[Signature]
Date:	06/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	[Signature]

DART AEROSPACE LTD	Work Order:	28863
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.122	.122	.122		
B	0.100	0.140		.121	.121	.122	.121		
C	0.100	0.140		.120	.119	.120	.119		
D	0.210	0.230		.220	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.578	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.238	.237	.238	.238		
N	0.100	0.140		.119	.118	.119	.118		
O	0.540	0.560		.552	.552	.550	.550		
P	0.490	0.510		.499	.500	.499	.499		
Q	3.715	3.725		3.720	3.721	3.720	3.721		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.252	.251	.253	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.636	1.629	1.630		
V	1.362	1.372		1.367	1.366	1.367	1.367		
W	0.316	0.321	DT8690	.318	.318	.318	.318		
X	1.250	1.270		1.259	1.258	1.260	1.259		
Y	1.565	1.585		1.571	1.571	1.572	1.571		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	06/10/10

Audited by:	[Signature]
Date:	06/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	[Signature]

